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1405-13

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QC

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Quality Control

QC9-Inspect visual per QS1004- Fusion Welds

Memo

DQA:		Date:			72								
					WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	0/2/07	7 0 1	***	AEROSPACE	
QA Closed:		Date:						((5)(1)	Wo	ork Order up	date only	100	
Work Order					DISPOSITION			AGAINST	T DE	PARTMENT/PROCESS			
					Rework		0	Skid-tube Crosstube	e		Water Jet	Engineering	
Part No	9.	Flish			Scrap		1	Machining Small Fat			d. Eng. Coor.	Quality	
					Use-as-is		Therr	moforming Finishing		Rec/Stor	e/Packaging	Other	
NCR N	0				Suspected Unapproved			Large Fab Composite	=	l	Supplier		
Root	1			Dosc	ription of work order update		nitial	Action	_	Sign &		ALC THE MAN	
Cause	Da	ie Step	Qty	Desc	or non-conformance	1	ief Eng	NAME OF TAXABLE PARTY.		Date	Verification	QC Inspector	
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	Ben	ling			Bend		Folio/I	Program		Outside Dim	ensions	Pressure/Forced	
		re Not Conce	entric		BOM/Route		Grain	11 111		Over/Under	tolerance	Set-up	
	Crac			16.1	Broken/Damage/Defect		Hardw	are		Part Incorred	i.	Temperature/Cure	
	Crim	p/Kink/Rippl	e/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
E STEEL	Cuff			die de	Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	Cras	hing		計量	Countersink		Misali	gned/off center		Positioned V	Vrong		
7	H∉a	Treat			Cut Too Short		Mislab			Power Loss/	Surge	Other	
	MINER THE PARTY	ection Strip is	n Tube		Drawing	Misread							
		cs/Chatter			Drill Holes		Off-set			1			
		ing Sequence			Finish								
100	Was	e/Twist in Tu	ing .	ATT THE PERSON	Fit/Function		IOut of	Sequence					

Work Order ID 116948

116948

Page 2

April-24-14 8:43:35 AM

Item ID: Revision ID: Item Name:	D3512-041 Wearplate Ass	sembly		Accept	*N900	0401	nn	* Se	tup Star Stop	I U.	S1*
Start Date: Required Date: Reference:	4/23/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:		Ri			71*
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*NF	₹2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		CONTRACTOR OF THE PARTY OF THE	pleteness to step on W/O	0.00							
140		Memo		0.00				P	X	14-05-1	9
Quality Control									2		9-89
150		Identify as per dwg &	Stock Location:	0.00				/			
150 Packaging		Memo	SMIP	0.00				1	191	3 (4	/_
Packaging											
160		QC21- Final Inspectio	n - Work Order Release	0.00							
160								ML:	7	14-05-1	3
QC		Memo		0.00				1.10.			1
Quality Control								1	7		
								(H	711-0	5-13	

DQA:		Date:		B/H	· DART									
					WORK ORDER NON	I-CC	ONFO	RMANCE / UPDATE				AEROSPACE		
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					DISPOSITION			AGA	INST DE	PARTMENT/PROCESS				
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Don't Ma					Rework	- 1			Il Fab	Dro	Water Jet d. Eng. Coor.	Engineering Quality		
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NCR No					Suspected Unapproved	+ 1	men	Large Fab Comp		Nec/Stor	Supplier	- Other		
INCK NO					Suspected Onapproved_	-		comp	,osite	!	ouppiic.			
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Doc/Data				14		1								
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Operator												1		
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Supplier				i i										
Training		THE P	13											
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Unapproved		1	-	100		EA	III T CA	TEGORY				14.72		
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10年 11年		ot Conce	ntric		BOM/Route		Grain	i de dia		Over/Under	tolerance	Set-up		
Centre Not Concentric Cracks					Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure		
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	tion Incomplete/Unqualifie	d	Part Lost/M	issing	Weld		
Cuffs					Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
	Crushing			2	Countersink		Misali	gned/off center		Positioned V		- mail		
	Heat Trea	at			Cut Too Short	Short Mislab				Power Loss/	Surge	Other		
Inspection Strip in Tube					Drawing		Misrea	d						
Marks/Chatter					Drill Holes		Off-set							
	Turning S	Sequence	3	1	Finish		Out of Calibration					7.4		
	Waye/Ty	wiet in Tu	ha	0	Fit/Function Out of Sequence									

April-24-14 8:43:38 AM

Work Order ID: 116948

116948

Parent Item:

D3512-041

Parent Item Name: Wearplate Assembly

D3512-041

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 6.00

Required Qty: 6.0%

Comments:

IPP REV: A 13.07.19 NEW ISSUE DD VERF:JLM

IPP

REV:B 13.12.11 ECN13-619/ REV.D DWG DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3512-1		Manufactured	No				Each	8.0000		8			
D3512-1 Stainless Steel Wearplate									**	#	200	0	14-05-13

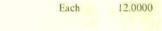
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Location Loc Qtv Loc Code 2 FG 89154 2 ST500 6 106042 6

D3512-3

Manufactured

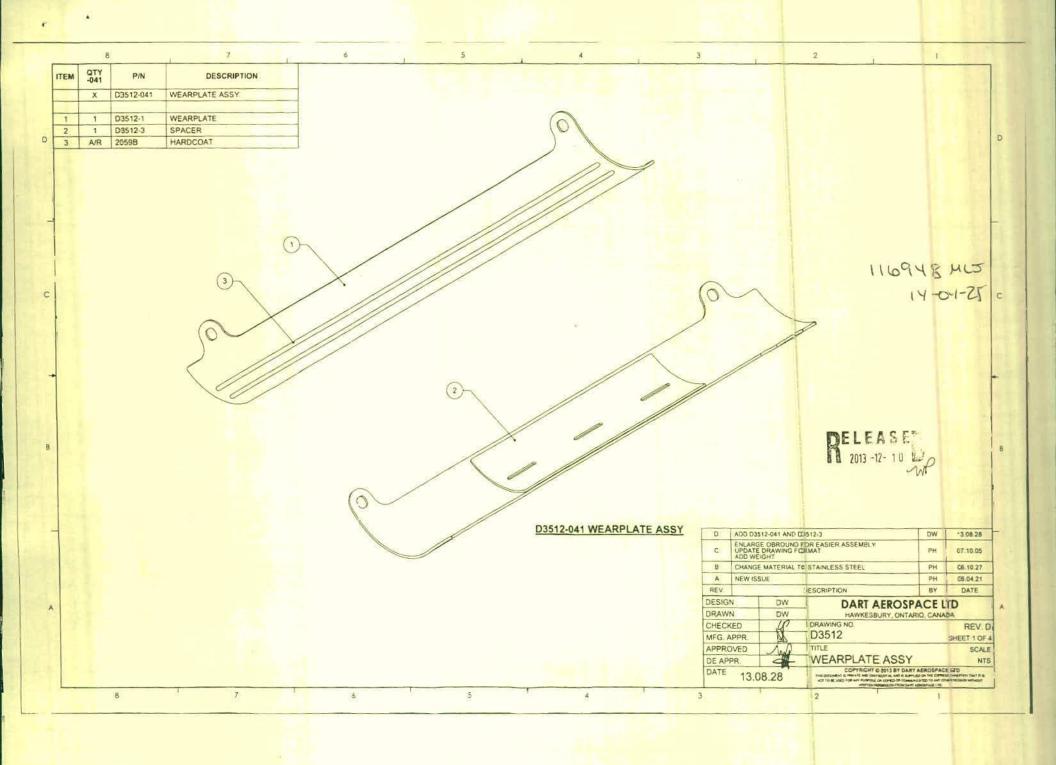


D3512-3

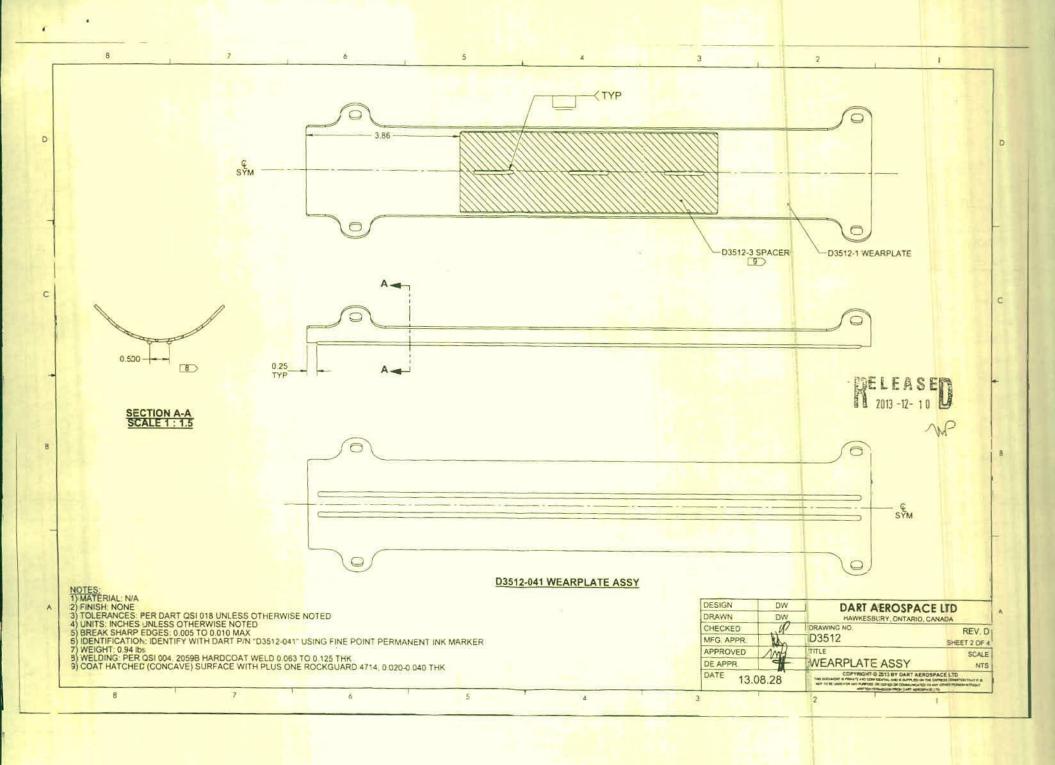
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Location	Loc Qty	Loc Code
WA001	12	
113028	12	

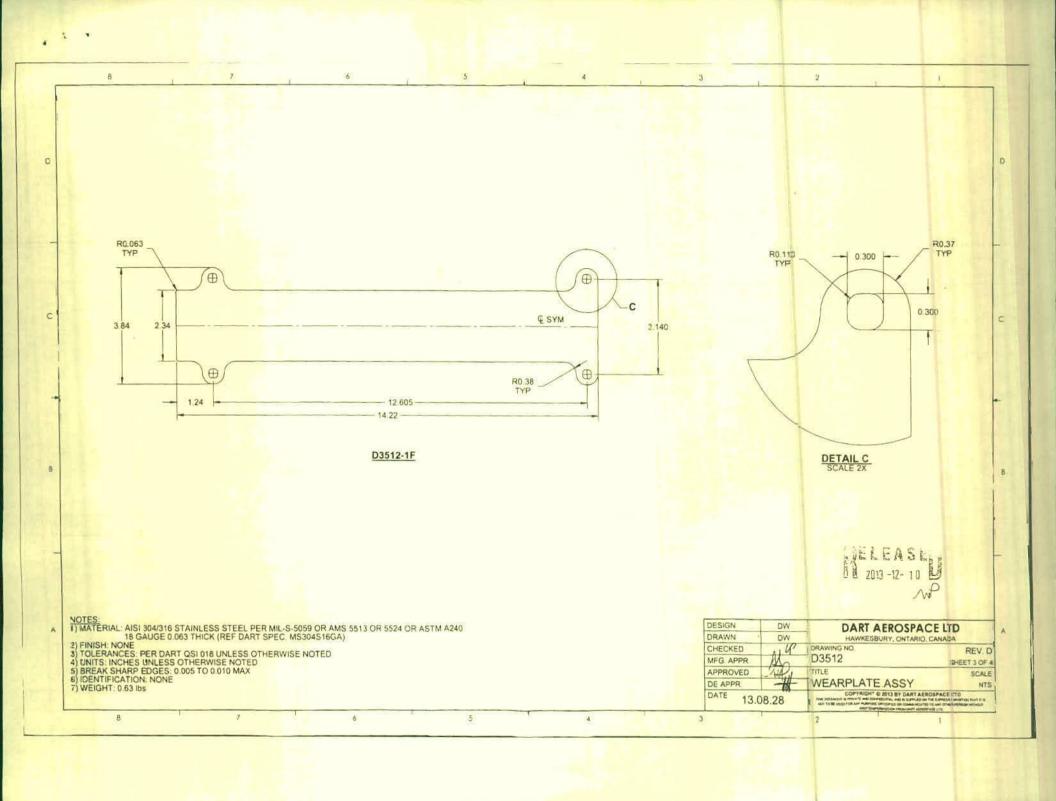
DQA:		Date:		Same	PART									
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	Wo	ork Order up	date only	AEROSPACE		
		Date.			DISPOSITION			AGAINST		PARTMENT/PROCESS				
Work Order						, I		Children La Conservation			Water Jet] Facinossing		
0 - 1 1					Rework	-		Skid-tube Crosstube Machining Small Fab	\vdash	Drog	d. Eng. Coor.	Engineering Quality		
Part No).				Scrap Use-as-is	1		noforming Finishing	$\overline{}$		e/Packaging	Other		
NCR No					Suspected Unapproved	1	men	Large Fab Composite		Nec/Stor	Supplier	Other		
No.	-				Suspected onapproved	1		composite	ш					
Roct	1			Desc	ription of work order update	1	nitial	Action		Sign &		阿拉纳		
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Doc/Data		17.70						ALET CONTRACTOR				FX(表)		
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Materia	Name of the last		A.											
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Offset/Setup				n in										
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Supplie:		100		1								12.7		
Training		1												
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Unapproved				1 385 Wa	1901	<u> </u>								
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Landin				_	General Bend		Tralia /	Program		Outside Dim	ensions	Pressure/Forced		
	Bending	Not Conce	ntein		BOM/Route		Grain	riogiani	\vdash	Over/Under	_	Set-up		
學工業	Cracks	NOT COILCE	nunc		Broken/Damage/Defect		Hardw	are	\vdash	Part Incorrec		Temperature/Cure		
		ink/Ripple	Altava		Burrs	-		tion Incomplete/Unqualified		Part Lost/Mi		Weld		
	Cuffs	III K/ Kippic	e ve ave		Contamination	-	-	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
Crushing					Countersink			gned/off center		Positioned V		_		
Heat Treat					Cut Too Short		Mislab			Power Loss/		Other		
Inspection Strip in Tube					Drawing	Misread								
Marks/Chatter					Drill Holes	Off-set				1				
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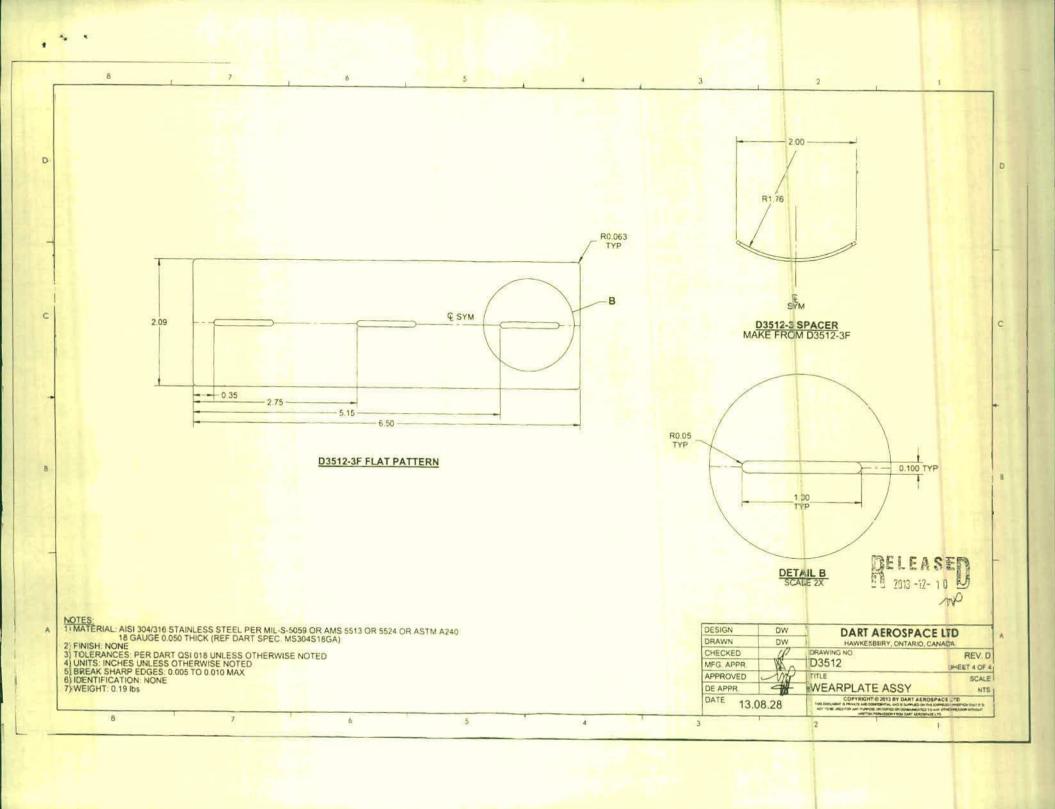
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QA Closed:		Date:							Wo	rk Order up	date only			
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70.7				4	Rework			Skid-tube Crosstube			Water Jet	Engineering		
Part No.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality		
A PARE	TEXT TO I			4	Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging	Other		
NCR No.				167	Suspected Unapproved			Large Fab Composite			Supplier			
Of Earlie				DE L	Back				_	61 0		25/77		
Roo∜			-	Des	cription of work order update		nitial	Action		Sign &	Verification	OC Inconcetor		
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Doc/Data				31				444						
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	Crushing				Countersink		A STATE OF THE PARTY OF	gned/off center		Positioned V				
	Heat Trea			A. C	Cut Too Short		Mislab			Power Loss/		Other		
	Inspectio		Tube	100	Drawing		Misrea	d						
Marks/Chatter					Drill Holes	Off-set								
	Turning S	Sequence		41	Finish	Out of Calibration								
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DQA:		Date:		E811	• Helponiantes and to be come an account	DART						
					WORK ORDER NON	I-CO	ONFO	RMANCE / UPDATE	147-	-l- O-d	daka asta - F	AEROSPACE
QA Closed:		Date:		Sale in	J4520				VVC	ork Order up	date only	
Work Order:					DISPOSITION							
	450000				Rework			Skid-tube Crosstube	9	Water Jet Engineerin		
Part No.				Rain .	Scrap			Machining Small Fall	d. Eng. Coor.	Quality		
				5	Use-as-is		Therr	moforming Finishing	g	Rec/Stor	re/Packaging	Other
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	Crimp/Ki	nk/Ripple	/Wave		Burrs		-	tion Incomplete/Unqualified		Part Lost/M	-	Weld
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j j	Marks/Cl				Drill Holes		Off-set					1 % y
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1 1		vist in Tu			Fit/Function		-	Sequence				16年7



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		Inspectio	n Strip in	Tube		Drawing		Misrea	d	V					
		Marks/Ch	natter	1	1	Drill Holes	1	Off-set							
		Turning S			15	Finish		A CONTRACTOR OF STREET	Calibration						
	1	Wave/Tw	vist in Tub	be	- Pa	Fit/Function	1	Out of	Sequence						



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QA Closed:			Date:			Taran.				Wo	ork Order up	date only			
Work Order						DISPOSITION			AGAINST						
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Part N	O.					Scrap	Machining Small Fab				Pro	Quality			
	Ī	Teat I				Use-as-is			noforming Finishing	$\overline{}$		re/Packaging	Other		
NCR N	0.					Suspected Unapproved			Large Fab Composite	$\overline{}$		Supplier			
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	. 161	Date	Verification	QC Inspector		
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1 - 4 - 4							FA	ULI CA	TEGORY				120		
Landin						General Bend		lealia/	Program		Outside Dim	ensions [Pressure/Forced		
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			k/Ringle	/Wave		Burrs	-	-	ion Incomplete/Unqualified		Part Lost/M	_	Weld		
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		Heat Trea		B1 8		Cut Too Short		Mislab			Power Loss/		Other		
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i i	-	Marks/Ch			1 3 7	Drill Holes		Off-set					N Section 1		
4		Turning S				Finish		parameter and the	Calibration						
		Wave/Tw			III R	Fit/Function		Out of	Sequence						